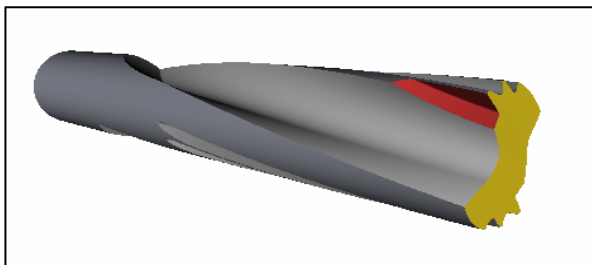















## Reamer Ø14 Z2

A01-011

Due to the geometry of the tool Flute 2, Flute 3 and Flute 4 operations are ground with a 11V9 wheel defined spindle side



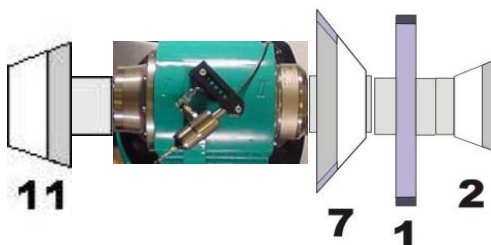
### 1. Cycletime for Production

Workpiece:	Diameter 14 mm, Z 2, Length of cutting edge 130 mm, Helix angle 10° Material: Carbide						
Operations							
	Probe	Flute 1	Gashing	End 1	Flute 2	Flute 3	Flute 4
Feed [mm/Min]	2000	80	100	100	100	100	100
Power [kW]		9	4	5	5	5	5
Cutting feed [m/s]		32	32	32	50	50	
Used wheels							
Grinding time [s]	6	235	46	20	192	192	192
Total cycle time	14 Min 41						

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	1A1 Ø100 B106
2	11V9 Ø75 B106
7	12V9 Ø125 B106
11	11V9 Ø100 B106



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG      Coolant: Synthetic Oil, pressure 6 bar  
Control: Fanuc 160i      Software: Quinto 5  
Accessories:

Responsible engineer: SBA, 18.11.09

[www.schneeberger.ch](http://www.schneeberger.ch)

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